June-04-12 1:25:41 PM

Item ID:

D350-636-011

04/06/2012

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name: Skidtube LH

Cust Item ID:

Required Date: 18/06/2012

Start Qty: 1.00 Req'd Qty: 1.00

Operation

Customer:

Reference:

, Approvals:

Sequence ID/

Process Plan: MLJ Date: 12/010/04 Tooling:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool ID Tool # Plan

Reject

Qty

Accept

Qty

Code

Insp.

Stamp

Work Center ID			Description					
	Draw Nbr		Revision Nbr					
	D2750		F					
	D3492		С					

DOCUMENT CONTROL

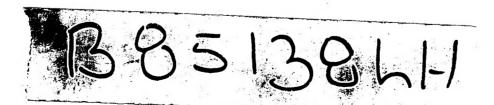
Memo

Reject

Number

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006



Dart Aeı	rospace	e Ltd							1
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	on:	QA: N/C C	losed:		Date: _	
NCR:	(1)		WORK ORD	DER NON-CONFORMAN	ICE (NCI	₹)			
DATE	0750	Description of NC		Corrective Action Section		Verifi	ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
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9	:								

Work Order ID 8 <i>June-04-12 1:25:41 PM</i>	5138	*85	138*			Page 2
Item ID: D350-636- Revision ID: Item Name: Skidtube LF		Accept	*N900040	1100*	Setup Start Stop	*NS1* *NS2*
Start Date: 04/06/2012 Required Date: 18/06/2012 Reference:		*1* *1*	Cust Item ID: Customer:		,	,
Approvals: Process P	Plan: Date	e: Tooling: e: SPC (Y/N):	Date:	- ·	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID Tool #	Plan Accept Code Qty	-	Reject Insp. Number Stamp
110 Skidtubes	Skidtubes Memo	0.00 BE 12/06/	1. –			
Skidtubes	AFT end per dwg D2 3- Drill pilot holes for deburt. 4- Locate DT8330 of fitting 5- Drill only two fwc 6- Drill pilot holes as Jig DT8150 & DT88 7- Clecko DT8863B ***SECOND SIDE*	AFT ends, remove bending marks. Scril 1750 or blade fitting bolt holes using DT8983 of of blade fitting bolt holes and drill pile of the property of the pro	to be batch# inside $\frac{BE12/06}{S}$ Open to 0.500", ot holes for blade $\frac{BE12/06}{S}$ of holes for blade er positioning. $\frac{BE12/06}{S}$ ond side (detail B) oles for detail B.	2-06-28	. *** *********************************	, m ¹ ,
	9-Drill pilot holes fo 0.297".	dling and detail C to 0.500" (8 holes per wearplates as per Dwg D2750 using D Detail A to 0.297" (total of 2 holes per	T8108 open to	B 12/06/	28	œ

Dart	Aeros	pace	Ltd

W/O:	İ		W	ORK ORDER CHANGI	ES			•	
DATE	STEP	PROCI	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date: _	·
	R	esolution:	Disposit	ion:	_ QA: N/C C	losed:		Date: _	
NCR:		WC	ORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B Sign Date	& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
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June-04-12 1:25:41 PM

Item ID: Revision ID:	D350-636-01	11		Accept	*N900	1040	1100)* s	Setup Star	171	S1*
Item Name:	Skidtube LH								Stop	° *N.	S2*
Start Date: Required Date:	04/06/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer						
Reference:	10,00,2012	neq a Qiy. 1.00	~1 ~		Customer	•					
		n:		Tooling:	I	Date:		R	Run Star Stoj	" " V	R1*
	QC:		Date:	SPC (Y/N):	I	Date:				*N	R2*
Sequence ID/ Work Center I	D	from bendi	2744 Cap as per Dwg D275 ng as per QSI 004	_		Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			ninum Rod batch: /////		BC12/06/	24					
120 *120*		QC10- Inspect visual pe	er QS1004- ground welds	0.00	106178						
QC Quality Control		Memo		0.00	184100						-
*130		QC5- Inspect part comp	oleteness to step on W/O	0.00	106/78						
QC Quality Control		Memo		0.00							4 =

Dart A	Aeros	pace	Ltd
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W/O:				• 3				
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	
Resolution:			Disposit	ion:	QA: N/C C	losed:	Date: _	
NCR:		V	VORK OR	DER NON-CONFORM	ANCE (NCF	R)		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	ction B Sign & Date		Approval Chief Eng	Approval QC Inspector
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Page 4

Insp.

June-04-12 1:25:41 PM Item ID: D350-636-011 Accept *N900040100* Setup Start **Revision ID:** Item Name: Skidtube LH 04/06/2012 Start Qty: 1.00 **Start Date: Cust Item ID: Required Date:** 18/06/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: **Tooling:** Approvals: Date: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool# Plan Reject Set Up/ Accept Reject **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 140 Chemical Conversion Coat per QSI005 4.1 0.00 *140* HandFinish 0.00 Memo

150

QC7-Inspect Chemical Conversion Coat

0.00

150 QC

Quality Control

Hand Finishing

Memo

0.00

W/O:		•	W	ORK ORDER CHAN	GES			•	
DATE	STEP	PRO	CEDURE CHA	DURE CHANGE B			Date , Q	Approv Chief En	g/ Approvai
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Part No:	•	PAR #:	Fault Cate	egory:	NCR:	Yes N	lo DQA:_	Date	:
	Re	esolution:	Dispositi	on:	QA: N	/C Clos	sed:	Date	e:
NCR:		V	VORK ORD	ER NON-CONFORM	IANCE (I	NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng) S	ign & Date	Verificati Section C		
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June-04-12 1:25:41 PM

Item ID: Revision ID: Item Name: Start Date:	D350-636-0 Skidtube LH 04/06/2012	Start Qty: 1.00	*1*	Accept		040100) *	Setup Star Stop	171	S1* S2*
Required Date: Reference:		Req'd Qty: 1.00	*1*		Cust Item I Customer:	D:				
Approvals:		in:		_ Tooling:		nte:]	Run Star Stop	1/1	R1* R2*
Sequence ID/ Work Center II 160 *160* Skidtubes Skidtubes	D	side) as per dwg l 2-Open up l as per dwg l 3- Open floa 4-Chamfer l (welding ins 5-Deburr an 6- Prepare to 7-Bond web A/R Sika 8- Weld spa (welding ins A/R Alumi	D2750. noles of Detail B to 0.750 D2750. at hole to 0.500" (4 per signature of Detail B, C, group structions on sheet 8) ad blow out all chips from the properties of D2739 in place as per Q affex-291 batch: 12 exp	inside of tube alodine as required. SI 015 19409 date: /3-4-/2 and D2743 as per dwg D27	per dwg D2750	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Dart Aerospace Lte	d	
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W/O:			V	ORK ORDER CH	ANGES				311	
DATE	STEP	PROC	EDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			4.							
Part No	:	PAR #:	_ Fault Ca	tegory:	NCI	R: Yes N	lo DQA:		_ Date: _	
	Res	solution:	Disposit	ion:	QA	N/C Clo	sed:		Date:	
NCR:		W	ORK OR	DER NON-CONFO	RMANCE	(NCR)				
DATE	STEP Description of NC		Corrective Action Section Initial Action Description			vei		Verification	Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Section	С	Chief Eng	QC Inspector
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June-04-12 1:25:41 PM

Item ID:

D350-636-011

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name: Skidtube LH

Required Date: 18/06/2012

04/06/2012

Start Oty: 1.00 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date: _____

Tooling:

SPC (Y/N):

Date:

Run

Date:

Sequence ID/ Work Center ID Operation Description

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Reject

Reject

11-Spot face ground handling holes section (total of 4 places per side) as per

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

170

QC

Memo

57/07/09

Quality Control

180

QC5- Inspect part completeness to step on W/O

5 7/07/09

180

QC Quality Control

Memo

0.00

Start

Stop

Qty

Number Stamp

Insp.

Dart Aerospace Li	td
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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85138

Page 7

June-04-12 1:25:41 PM Item ID: Accept D350-636-011 *N900040100* Setup Start **Revision ID:** Item Name: Skidtube LH **Start Date:** 04/06/2012 Start Qty: 1.00 Cust Item ID: **Required Date:** 18/06/2012 Req'd Qty: 1.00 **Customer:** Reference: Run **Approvals:** Process Plan: Date: **Tooling:** Date: Stop OC: SPC (Y/N): Date: Date: Operation Sequence ID/ Set Up/ Tool ID Reject Tool # Plan Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp Pressure Wash per QSI005 4.3 190 0.00 *190* HandFinish 0.00 Memo Hand Finishing Re-alodine tube as per OSI 005 section 4.1.2.1 do not acid etch. 200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 Powdercoat Memo START TIME: Powder Coating OVEN TEMPERATURE: FINISH TIME: 210 QC3- Inspect Part Finish 0.00 1 hl & Al 12/07/10 *210* 0.00 Memo Quality Control Inspect for foreign object per QSI 024

Dart Aerospace	Ltd
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W/O:		ies							
DATE	STEP	PRO	OCEDURE CHAI	DURE CHANGE By				Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\:	Date:	
,	R	esolution:	Disposition	n:	QA: N/C Cld	sed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE STEP		Description of NC			on B Sign &	Verific		Approval	Approval
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June-04-12 1:25:41 PM

Item ID: D350-636-011

Required Date: 18/06/2012

Accept

N900040100

Setup Start

Stop

Item Name: **Start Date:**

Revision ID:

Skidtube LH 04/06/2012

Start Oty: 1.00 **Req'd Oty:** 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

0.00

0.00

0.00

Date:

Run Start

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ Work Center ID 220

220

HandFinish Hand Finishing Operation Description

HandFinishing

Memo

✓ 1- Install inserts as per Dwg D2750

Tool ID

Tool #

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

230

HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: N L

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241

BATCH: (A) 111 13 0 EXP DATE: 1010348

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: /L/\ ((0)

5-Coat all exposed fasteners with "LPS Procyon" batch: JALIY 59 b

Land & Maloalic

	John C.									
W/O:			W	ORK ORDER CHANG	ES				,	
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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					·					
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Y	es N	o DQ	A :	_ Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/	C Clos	ed:		Date:	
NCR:		\	VORK OR	DER NON-CONFORMA	ANCE (N	ICR)				
DATE STEP		Description of NC Corrective Action			ion B		Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Pate	Secti	on C	Chief Eng	QC Inspector
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Work Order ID 85138

85138

Page 9

June-04-12 1:25:41 PM

Required Date: 18/06/2012

Item ID:

D350-636-011

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name:

Skidtube LH 04/06/2012

Start Qty: 1.00 **Reg'd Oty:** 1.00

Date:_____

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date: Date: Run

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours**

SPC (Y/N):

Tool# Plan

Code Qty

Reject Accept Qty

Reject Number Stamp

Insp.

240 *240*

Memo

QC5- Inspect part completeness to step on W/O

5.71ALU

Quality Control

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4-100% Inspect kits for completeness

0.00

260

Memo

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/O:		•	W	ORK ORDER CHANG	GES .						
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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DATE	STEP	Description of NC	of NC Corrective Action Se			verification			Approval		
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June-04-12 1:25:41 PM

Item ID:

D350-636-011

Accept

N900040100

Setup Start

Stop

Revision ID:

Skidtube LH Item Name:

Start Date: 04/06/2012 **Required Date:** 18/06/2012 Start Qty: 1.00 Req'd Qty: 1.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

QC:

Date: Date: **Tooling:**

SPC (Y/N):

Date:

Run

Reject

Qty

Accept

Qty

Date:

Stop

Number Stamp

Insp.

Reject

Sequence ID/ **Work Center ID**

270

270

Packaging

Memo

Operation

Packaging

Description

Packaging Package as per PPP D350-636-011

QC21- Final Inspection - Work Order Release

Memo

280

Quality Control

280

QC

Set Up/ **Run Hours**

0.00

0.00

0.00

0.00

Tool #

Plan

Code

MLJ12107/13 MLJ12107/13

Dart Aerospace Ltd	
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W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	ANGE	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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NCR:			WORK OR	DER NON-CONFORM	IANCE	(NCR)							
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Picklist Print

June-04-12 1:25:45 PM

Work Order ID: 85138

D350-636-011

Parent Item Name: Skidtube LH

85138

D350-636-011

Start Date: 04/06/2012

Required Date: 18/06/2012

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

Parent Item:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ

Manufactured

No

IPP Rev:J 06-03-23

As per Rev D JLM

IPP Rev:K 06-07.13 As per dsi9343 EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec

IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010 DD verf:EC seq110 DD verf:EC

IPP Rev:P 10.06.22 revise

IPP Rev:Q 10.10.01 as per IIN revH

DD_verf:EC

	- Verribe												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1 *\bigcap 3492-1*		Manufactured	No			230	Each	257.0000	8	8 1 L		07/1	۵
Ü				<u>Location</u> FP002		Loc (<u>Oty</u> 242	Loc Code	_				

Location	Loc Qty	Loc Code				
FP002	242		_			
69531	8		_			
74444	2					
76235	4					
83259	228		_	X %		
FP-A	15		_			
83098	15		_			
	230 Eac	ch 167.0000	8	8		
		,	* *	M	10/07/10	

D3492-3

Plug

D3492-3

Location	Loc Qty	Loc Code
FP-A	167	
81967	5	
83099	40	
83529	122	

M 12/07/10

Dart Aerospace	Ltd	
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W/O:			WO	RK ORDER CHANGE	ES			3			
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			Fault Category: NCR: Yes								
Resolution:			Disposition	:	_ QA: N/C Cld	sed:		Date: _			
NCR:		V	WORK ORDE	R NON-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC	Corrective Action Section B				ication Approval	Approval	Approval		
	J	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector		
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June-04-12 1:25:46 PM									Page 2
Work Order ID: 85138		*8513	38*						
Parent Item: D350-636-011 Parent Item Name: Skidtube LH			N-636-()11*			art Date: 0- tart Qty: 1.		Required Date: 18/06/2012 Required Qty: 1.00
*NAS1611-010 *NAS1611-010* o-RING	Purchased	No		230	Each	188.0000	8 **	8 Hl	n102/10
		Loca	<u>ıtion</u>	<u>La</u>	oc Oty	Loc Code			
NAS1149D0863J *NAS1149D0863 WASHER	Purchased 3.1*	FP00	110915 117460 118077 118612 119438 121259 121415 121584 121723	250	100	251.0000) **	2	- - - - - - - - - - - - - - - - - - -
		Loca	<u>ition</u>	<u>L</u> (oc Qty	Loc Code			
		ST29	118078 119307 120308 121556		251 34 17 100 100			12030	- - <u>8</u>
D2744	Manufactured	No		110	Each	35.0000	1	1	_
D2744							**		Bargorpe
		Loca		Lo	oe Qty	Loc Code			
		LG0	62715 78900 83412		35 1 3 31				
June-04-12 1:25:49 PM		-		Packet Print	31				Page

Dart	Aeros	pace	Ltd
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Dart Aei	rospace	Lta							
W/O:			WO	RK ORDER CHANGI	ES				, .
DATE STEP		PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:			Disposition	:	QA: N/C Cl	osed:		Date: _	
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		Description of NC Section A		Corrective Action Section	Section B Verific			Approval	Approval
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date		Verification Section C	Chief Eng	QC Inspector
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June-04-12 1:25:49 PM

Work Order ID: 85138

Parent Item:

D350-636-011

Parent Item Name: Skidtube LH

85138 *D350-636-011*

Start Date: 04/06/2012

Start Qty: 1.00

Required Date: 18/06/2012

Required Qty: 1.00

Manufactured

Manufactured

No

110

Each

29.0000

**

Bf 12/06/23

D2600-3-BFNT

Extrusion Bent

D2600-3-BENT

<u>Location</u>	<u>1</u>	Lo	e Oty	Loc Code		
LG			29			
	66875		7			
	73253		1			
	75021		1			
٠.,	75022		1			
•	75023		1			
	81330		4			
	83305		i			
	83442		13			
		160	Each	296.0000	8	Q.

Crossbolt Spacer

D2743

Location	Loc Qty	Loc Code
LG	222	
81965	55	
83262	167	
LG001	74	
67766	4	
68251	3	
73403	64	

**

74445 79517

W/O:		/ WORK ORDER CHA	WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
		÷.										
		7.										
												
Part No	* <u>*</u>	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _						

Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: _____

	-	ER NON-CONFORMANC	NCE (NCR)				
T	Description of NC		Corrective Action Section B				A
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approva QC Inspecto
	fs. *			,			
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	- Year						
 							
	,						
		STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Action Description Chief Eng	STEP Description of NC Section A Chief Eng Corrective Action Section B Sign & Date Initial Chief Eng Ch	STEP Description of NC Initial Chief Eng Action Description Chief Eng Chief Eng Section C	STEP Description of NC Section A Chief Eng Chi

Picklist Print

June-04-12 1:25:50 PM

Work Order ID: 85138

Parent Item:

D350-636-011

Parent Item Name: Skidtube LH

85138 *D350-636-011*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

D2739

350 I Beam

Manufactured

Manufactured

Manufactured

No

No

No

160

Each

13 0000

De 12/07/05

Location Loc Qty Loc Code LG 72155 81508 83447 83448 5 2 83548 160 Each 46.0000 **

D3490-3

D3490-1

Cross Bolt Spacer

Location LG001

Loc Qty 46 83313 46 160 Each Loc Code

45.0000

**

Cross Bolt Spacer

Location Loc Qty LG 2 2 81976 LG001 43 62450 2 74875 77042 3 83269 34

Loc Code

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROG	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		7.444						1 Tod Migi			
											
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date: _			
Resolution:			_ Disposit	ion:	QA: N/C Closed:			Date:			
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCF	()					
DATE	CTED	Description of NC	Description of NC			on B Verification			Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Approval Chief Eng	QC Inspector		
		,									
					<u> </u>						
						-					

June-04-12 1:25:50 PM

Work Order ID: 85138

D350-636-011

Parent Item Name: Skidtube LH

85138

D350-636-011

Start Date: 04/06/2012

Start Qty: 1.00

Required Date: 18/06/2012

Required Qty: 1.00

ALS4-1032-225

Parent Item:

Purchased

No

220

Each

781.0000

38 **

12/07/10

ALS4-1032-225

<u>Location</u>	Loc Qty	Loc Code	
ST281	758	11122290	x3%
108696	146	//(1/ CC10	
110768	62		
118386	55		
118966	68		
121269	427		
ST282	23		
120410	10		
120451	13		

D3793-3

Manufactured

No

230

Each

28.0000

12/02/10

D3793-3

Location	Loc	e Qty	Loc Code
FP001		28	
83394		16	
83901		12	
	230	Each	68.0000

AN8C35A

Purchased

No

AN8C35A **BOLT**

<u>Location</u>	Loc Qty	Loc Code	
FP002	67		
115960	1		
118286	16		χ(
121275	50		
ST346	1		
114442	0		
115188	0		
115960	1		

Dait Aci	ospace	LIG							
W/O:			W	ORK ORDER CHANGI	ES			····	
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	!! :	PAR #:		egory:	NCR: Yes	No DQ	A:	Date: _	
		esolution:							
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign Date	& Secti	cation ion C	Approval Chief Eng	Approval QC Inspector
			James Ling	Onto Ling					
		-							
								i	
						1			1

June-04-12 1:25:50 PM

Work Order ID: 85138

Parent Item:

D350-636-011

Parent Item Name: Skidtube LH

85138 *D350-636-011*

Start Date: 04/06/2012

**

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-1

D3793-1

Wearshoe

Manufactured

Manufactured

Manufactured

No

No

230

Each

28.0000

Loc Code

D3488-041

Blade Fitting Assembly, LH

D3794-3

Gasket

Location Loc Qty FP001 28 2 82171 83393 13

83903 13 230 Each

9.0000 **

1207/10

Loc Code Location Loc Qty B85807 FP002 61689 82271 8 230 Each 23.0000

**

Loc Qty Loc Code Location FP 21 21 83396 FP002 2 74530 2

W/O:			W	ORK ORDER CHANG	ES				, ,
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C C	osed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC			ion B	Verific	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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		-							

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Work Order ID: 85138

Parent Item:

D350-636-011

Parent Item Name: Skidtube LH

85138 *D350-636-011*

Start Date: 04/06/2012

Required Date: 18/06/2012

Page 7

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

AN6C44A

MS21083C8

Purchased

No

230

Each

86 0000

**

12 12/07/10

Location		Loc Qty	<u>Loc Cod</u>	<u>e</u>		
FG		:	2			
	103964	1	2			
ST343		84	34			
	121013	i	11			
	121167	13	13			
	121440	50	50		_ X 4	
	121689	10	10		·	
		230	Each 81.0000	1	1	

MS21083C8

Purchased

No

**

11 12/07/10

Location Loc Qty Loc Code 304 75 121185 29 121349 46 FP002 115884 ST303 115884 118077 119309 119638 ST304

121524

Dail Aci	ospace	LU							
W/O:			WO	RK ORDER CHANG	ES	· · · · · · · · · · · · · · · · · · ·	-		, ,
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	,								
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	7 :	Date: _	
	R	esolution:	Disposition	:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCI	7)			
	,	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspector
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June-04-12 1:25:50 PM

Work Order ID: 85138

Parent Item:

D350-636-011

Parent Item Name: Skidtube LH

85138 *D350-636-011*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Oty: 1.00

**

**

Required Oty: 1.00

D3536-25

D3536-25

Gasket

Manufactured

Manufactured

Purchased

No

No

No

230

Each

28.0000

11/20 / 10 LR

Location Loc Qty Loc Code 28 83391 12 83900 16 D3631-1 230 347.0000 Manufactured No Each **

D3631-1

Washer

Location Loc Code Loc Qty FG 332 81874 2 83588 330 ST072 15 68062 2 75548 13 230 Each 17.0000

D3791-1

Wearplate

D3791-1

Location Loc Qty Loc Code FP002 17 62239 2 83392 15 230 Each 0.0000

12/02/10

*AN960C10! * 4

washer

AN960C10L

121063

** (x58) Il 12/02/10

Dail At	ospace	Lia							• • • • • • • • • • • • • • • • • • • •
W/O:		WWW 400 11 N	W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									; ;
Part No	:	PAR #:	Fault Cat	tegory:	_ NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositi	ion:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NC	₹)			
DATE	STEP	Description of NC		Corrective Action Secti		Verifi	cation	Approval	Approval
DAIL	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a		ion C	Chief Eng	QC Inspector
-									
			•						

Picklist Print

June-04-12 1:25:51 PM

Work Order ID: 85138

Parent Item:

D350-636-011

Parent Item Name: Skidtube LH

85138 *D350-636-011*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

AN3C5A

D2745 Bushing

Manufactured

No

230

Each

122.0000 **

		Location	Loc Qty
		FP	6
		79518	6
		FP001	116
		69529	1
		76142	1
		83260	114
Purchased	No	-	230 Each

1,302.000 **

Loc Code

12/07/10

AN3C5A Bolt

<u>Location</u>	Loc Qty	Loc Code
FP001	7	
115835	7	
ST350	1295	
116419	28	
117343	13	
117764	7	
117872	2	
119749	23	
120423	28	
121068	12	
1 <u>2125</u> 5	500	
121444	182	
121708	500	

W/O:			V	ORK ORDER CHANGE	ES			***************************************	
DATE	STEP	PROC	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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								·	
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQA	\:	Date:	
	R	esolution:	_ Disposit	lon:	QA: N/C C	losed:		Date: _	
NCR:	3	W	ORK OR	DER NON-CONFORMA	NCE (NC	R)	** · · · · · · · · · · · · · · · · · ·		
DATE	STEP Description of NC	Description of NC Corrective Action Section B				Sign & Verification			Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Date		on C	Chief Eng	QC Inspector
							,		

June-04-12 1:25:51 PM

Work Order ID: 85138

Parent Item:

D350-636-011

Parent Item Name: Skidtube LH

85138

D350-636-011

Start Date: 04/06/2012 Start Qty: 1.00

**

Required Date: 18/06/2012

Required Qty: 1.00

D3537-1

Manufactured

No

230

Each

83 0000

3

ISL 11/02/10

D3537-1

Wearpad

Location	Loc Qty	Loc Code	
FG	10	202251	
79833	10	1383256	
FP002	73		
69817	5		
81360	14		
81362	19		
83254	1		
83255	3		
84091	31		

NAS1149C0832R

Purchased

No

230 257.0000 Each

**

NAS1149C0832R

WASHER

Location	Loc Qty	Loc Code	
ST297	257		
114915	257		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	ŧ	,							
Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _		
Resolution: Disposition:			ion:	QA: N/C Closed: Date:					
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC			on B Verification		Approval	Approval	
	,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspector	
<u> </u>									
	1	-						İ	

June-04-12 1:25:51 PM

Work Order ID: 85138

Parent Item:

D350-636-011

Parent Item Name: Skidtube LH

85138 *D350-636-011*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

Purchased

No

230

Each

451.0000

**

AN3C6A

Location	<u>Lo</u>	c Oty	Loc Code		
FP001		1			
111982		1			
ST351		450			
111982		2			
116419		23			
116549		2			
116704		12			
117619		10			
117688		1			
117872		5			
118422		13			
119449		21			
120423		3			
120693		158			
121682		200			<u> </u>
	230	Each	361.0000	8	8

NAS1611-013

NAS1611-013

O-RING

<u>Location</u>	Loc Qty	Loc Code
FP001	361	
116582	5	
117291	2	
117887	53	
119623	36	
121584	15	
121825	200	
121826	50	

									*		
W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								, vou mg.			
Part No	<u> </u>	PAR #:	Fault Cat	egory:	NCB: Vas	No DOA	•	Date:			
· artivo		esolution:									
NCR:		V	VORK ORI	DER NON-CONFORM	ANCE (NCR)					
DATE	STEP Description of NC				tion B Verific			tion Approval	Approval		
	J. 2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	n C	Chief Eng	QC Inspector		
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		-									

Picklist Print

June-04-12 1:25:51 PM

Work Order ID: 85138

Parent Item:

D350-636-011

Parent Item Name: Skidtube LH

85138 *D350-636-011*

No

No

No

Manufactured

Manufactured

Purchased

Start Date: 04/06/2012

**

**

34.0000

Loc Code

Required Date: 18/06/2012

Required Qty: 1.00

Start Qty: 1.00

D3535-25

Wearshoe

D3535-25

Loc Qty Location FP001

34 62233 81357 82156 83387 83899

2 17 13 Each 26.0000

Each

20

2

96

Each

D3794-1

D3794-1

Gasket

Loc Code Location Loc Qty FP 6 82167 FP002 20 20

230

230

83395 230

618.0000 **

MS21043-6

NUT

MS21043-6

Location Loc Qty Loc Code FG 20

103693 ST301 598 117887 118384 120308 500

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Dart Aeı	ospace	Ltd					34, " "		
W/O:			WO	RK ORDER CHANGES					, ,
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty.	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	,							·.	
Part No		PAR #:	Fault Categ	ory: 1	NCR: Yes	No DQ		Date:	
	Re	solution:	Disposition	:	A: N/C C	losed:			
NCR:		V	VORK ORDE	R NON-CONFORMAN	CE (NC	R))			
5.475		Description of NC		Corrective Action Section E		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	CIIII IIII IIII COCTI	onC	Chief Eng	QC Inspector
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ST343

118758

121167

121275

Page 13

121275

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W/O:			WO	RK ORDER CHANG	ES			*	4 2	
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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	:									
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Ye	s No	DQA:	A: Date:		
, Resolution:		esolution:	Disposition	•	_ QA: N/C	Closed	!:	Date:		
NCR:		\	WORK ORDE	R NON-CONFORMA	ANCE (N	CR)				
DATE	STEP	Description of NC			ion B	n &	erification	Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng		ite	Section C	Chief Eng	QC Inspector	
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Picklist Print

June-04-12 1:25:51 PM

Work Order ID: 85138

Parent Item:

D350-636-011

Parent Item Name: Skidtube LH

85138 *D350-636-011*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each 146.0000

**

*NAS1515H3I *

Location	<u>1</u>	Loc Oty	Loc Code
FG		40	
	102472	40	
ST277		106	
	118686	3	
	119438	1	
	120360	11	
	121243	2	
	121556	89	
		250 Each	20.0000

Spacer

Blade, 350 Skidtube

Manufactured

**

83135 JB 5

Manufactured No Location Loc Code Loc Qty ST -10 ST466 30 71856 79516 19 250 Each

7.0000

**

83319 JB Q 12/67/11

Location Loc Qty Loc Code ST053 7

7

82041

June-04-12 1:25:52 PM

Shop Packet Print

Page 14

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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							4 38 7				
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Part No		PAR #:	Fault Cal	edory.	NCR: Y	es No IDO	A .	Date			
1 411 140	·	desolution:	Pionociti	on:	NON. 1				;		
1		resolution:	Dispositi	on:	QA: IVC	・ Eline Faller	HENRY HENRY	Date: _			
NCR:		,	WORK ORI	DER NON-CONFORM	MANCE (N	CH)					
DATE	STEP	Description of NC			ection B	Verifi	cation	Approval	Approval		
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	n Sig	gn & Sect	ion(C	Chief Eng	QC Inspector		
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•	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
	X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
		Х			D2750-042	350 SKIDTUBE ASSEMBLY, RH
			X	l	D2750-043	350 SKIDTUBE ASSEMBLY, LH
				X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
	1	1	1	1	D2739	WEB
	8	8	8	8	D2743	SPACER
	1	1	1	1	D2744	CAP
	8	8	8	8	D2745	BUSHING
	1				D2750-1	SKIDTUBE WELDMENT, LH
		. 1			D2750-2	SKIDTUBE WELDMENT, RH
			1		D2750-3	SKIDTUBE WELDMENT, LH
				1	D2750-4	SKIDTUBE WELDMENT, RH
	1		1		D3488-041	BLADE FITTING, LH
l i		1		1	D3488-042	BLADE FITTING, RH
	4	4	4	4	D3490-1	SPACER
	4	4			D3490-3	SPACER
			4	4	D3490-5	SPACER
	8	8	-8	8	D3492-041	PLUG ASSEMBLY
	8	8			D3492-043	PLUG ASSEMBLY
			8	8	D3492-045	PLUG ASSEMBLY
	1	1	1	1	D3535-25	WEARSHOE
	1	1	1	1	D3536-25	GASKET
Æ	3	_ 3	3	3	D3537-1	WEARPAD
_	- 8	8	8	8	D3631-1	WASHER
	1	1	1	1	D3791-1	WEARPLATE
! !	1	1	1	1	D3793-1	WEARSHOE
△┤│	1	1	1	1	D3793-3	WEARSHOE
Æ	1	1	1	1	D3794-1	GASKET
LI	1	1	1	1	D3794-3	GASKET
_						
Æ	38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
	34	34	34	34	AN3C5A	BOLT
_ 1	4	4	4	4	AN3C6A	BOLT
I	4	4	4	4	AN6C44A	BOLT
[1	1	1	1	AN8C35A	BOLT
A_[38	38	38	38	AN960C10L	WASHER
	1	1	1	_1_	AN960C816L	WASHER
	4	4	4	4	MS21043-6	NUT
ł						
	1	1	1	1	MS21083C8	NUT

SHOP COPY **RETURN TO ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 85138 MLJ 12/06/04

F	INCORPORATE DIS19413. OTY (3) DS37-1 WAS QTY (5) (ZN C8-1). D3791-1/-3 REPLACES D3535-13/-35 (ZN B8-1). D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1). ADD D3791-1 (ZN G8-1). WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE OTY UPDATED (ZN B8-1). D3488-041-042 HARDWARE UPDATED (ZN C1-8 9, 10, 11). ADD NOTE 12 AND 13 (ZN A6-1). REASON REF. NOK 06-045.	РН	08 07 16
E	CHANGE TO STAINLESS STEEL WEARPLATES: ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L, REMOVE QTY (10) NAS1515HBL, REMOVE D2741, QTY (2) AN950C816, REMOVE QTY (2) MS21083C6	СВ	07.05.17
D	ADD HOLES AND SHACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
С	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	98.11.18
В	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
Α	NEW ISSUE	DŞ	98.04 16
REV	DESCRIPTION	DV	DATE

REV			DESCRIPTION	DATE							
DESIGN	v .	PÚ,	DART AEROSPAC	DART AEROSPACE USA, INC.							
DRAW	<u> </u>	PAL	PORT HADLOCK, WA								
CHECK	ED	1,15	DRAWING NO.		REV. F						
MFG. APPR.			D2750	SHEET 1 OF 11							
APPRO	VED	IM	TITLE		SCALE						
DE APF	PR.	1	☐ 350 SKIDTUBE ASSI	EMBLY	NTS						
DATE	08.0	7.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THE DOCUMENT IN PRINTE AND COMPRENTING AND IS SUPPLIED ON THE EXPRESS CONCION THAT I' IS								

GENERAL NOTES:

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MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

MATERIAL: MAKE D2750-11-24-34-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: N/A
IDENTIFICATION. D/S/
WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS

WELD PER DART QSI 044 - 26.5 LBS
WELD PER DART QSI 004
INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø 0.297) FOR WEARSHOE INSERTS
FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 36 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER,
SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

ANY PURPOSE OR COPIED OF COMMUNICATED TO ANY O' WAITTEN PERMISSION FROM DART AEROSPACE USA INC

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:		Date: _					
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D D2750-041 350 SKIDTUBE ASSEMBLY, LH D2750-042 350 SKIDTUBE ASSEMBLY, RH DART AEROSPACE USA, INC.
PORT HADLOCK, WA DESIGN DRAWN CHECKED DRAWING NO. REV. F D2750 MFG. APPR. SHEET 2 OF 11 APPROVED TITLE SCALE 350 SKIDTUBE ASSEMBLY

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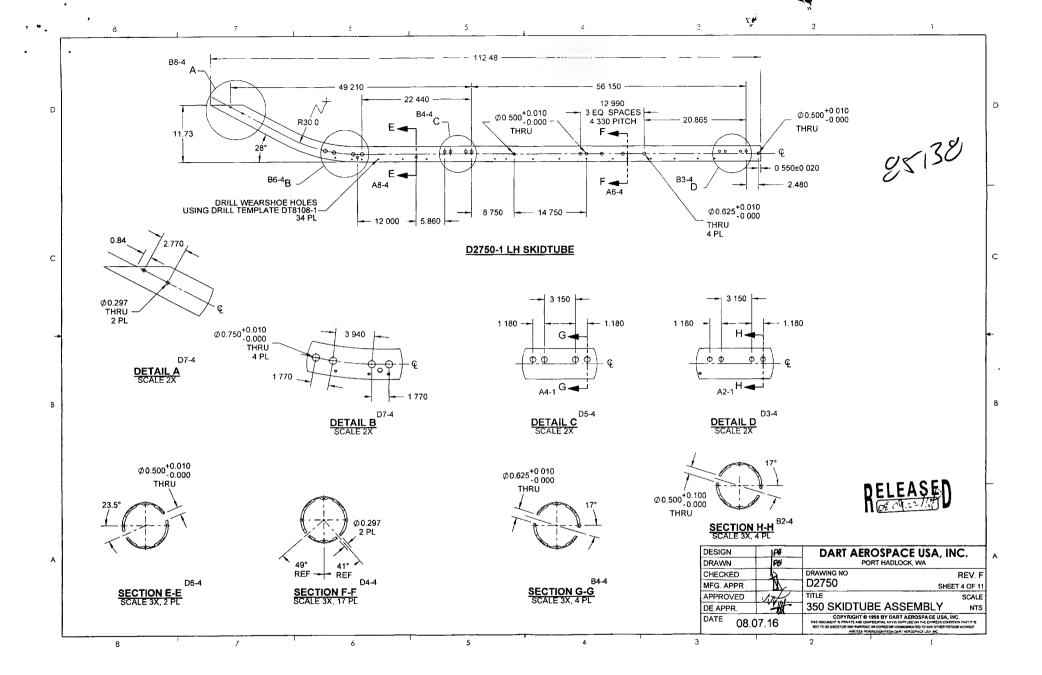
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PORT HADLOCK, WA DRAWN DRAWING NO D2750 CHECKED REV. F MFG. APPR. SHEET 3 OF 11 APPROVED 350 SKIDTUBE ASSEMBLY

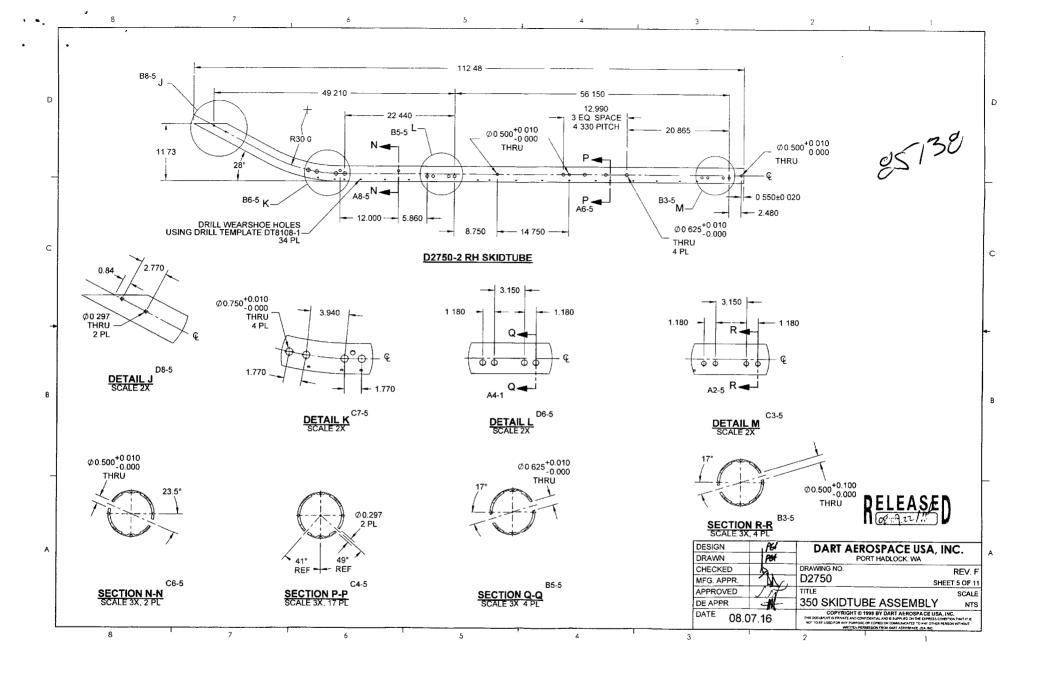
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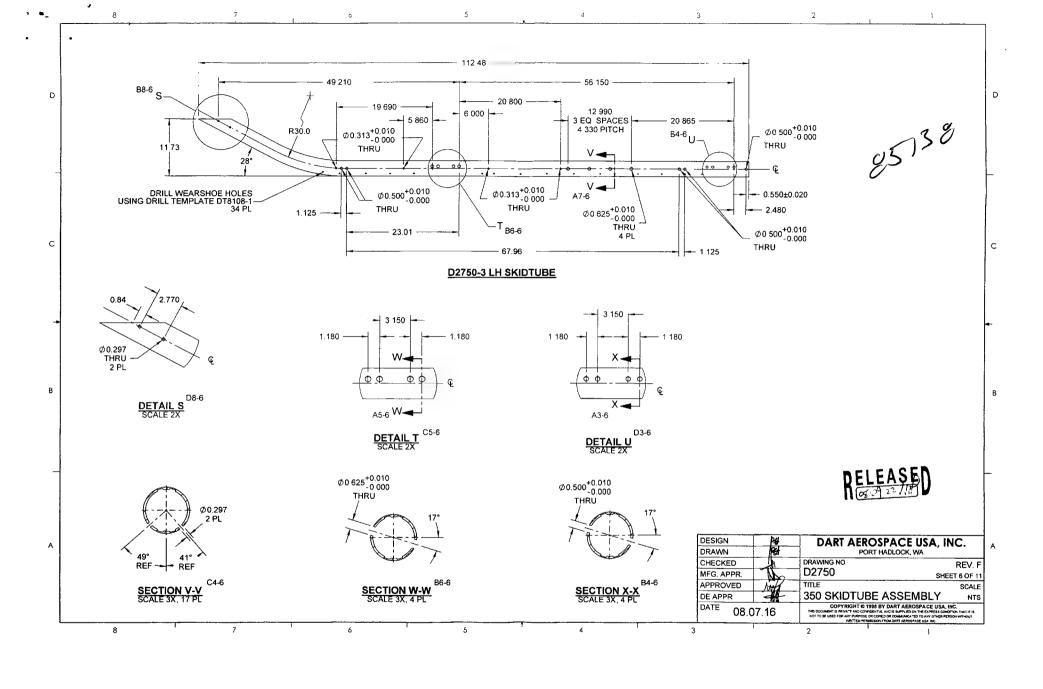


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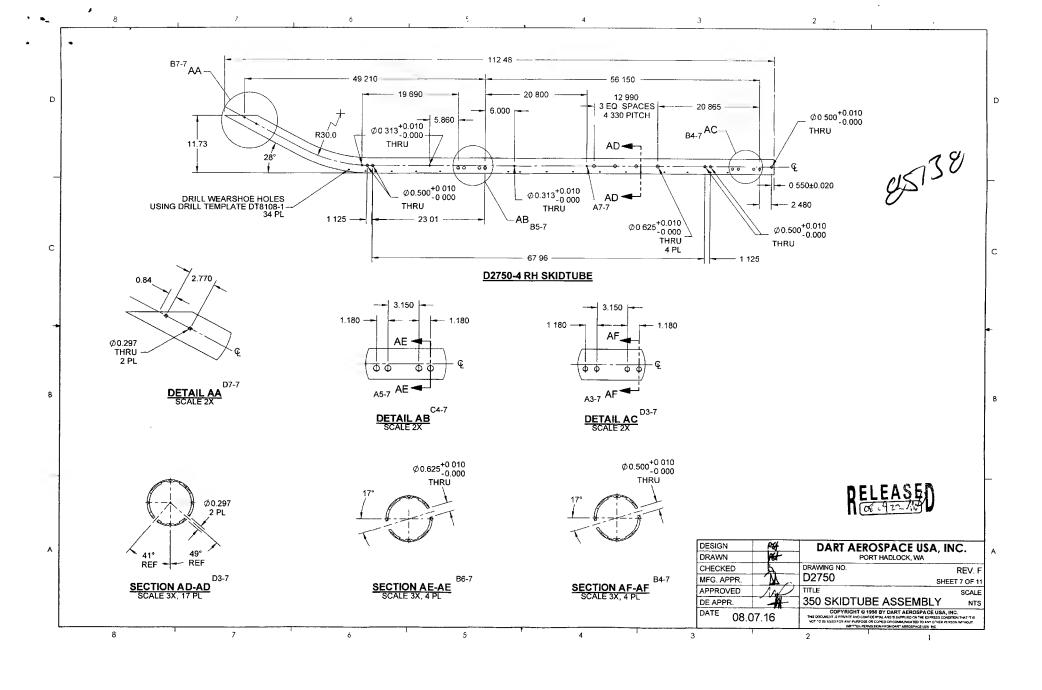


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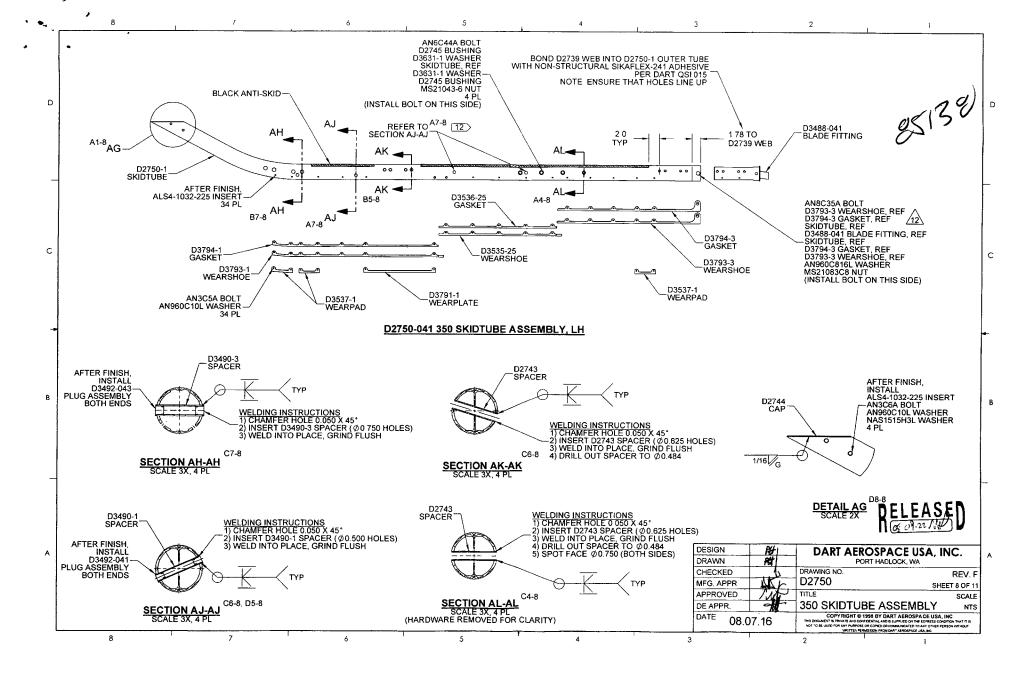
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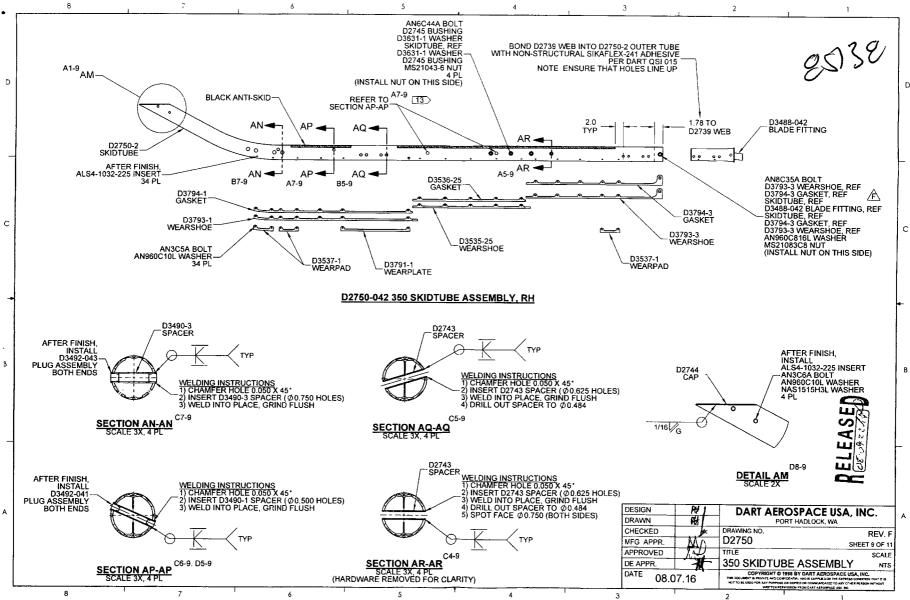


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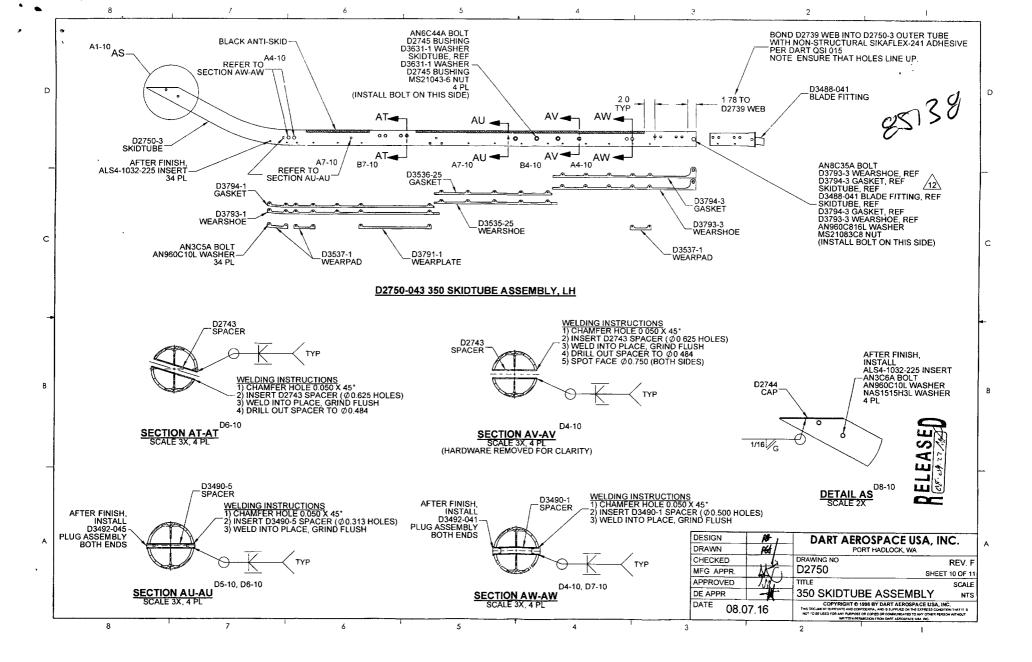


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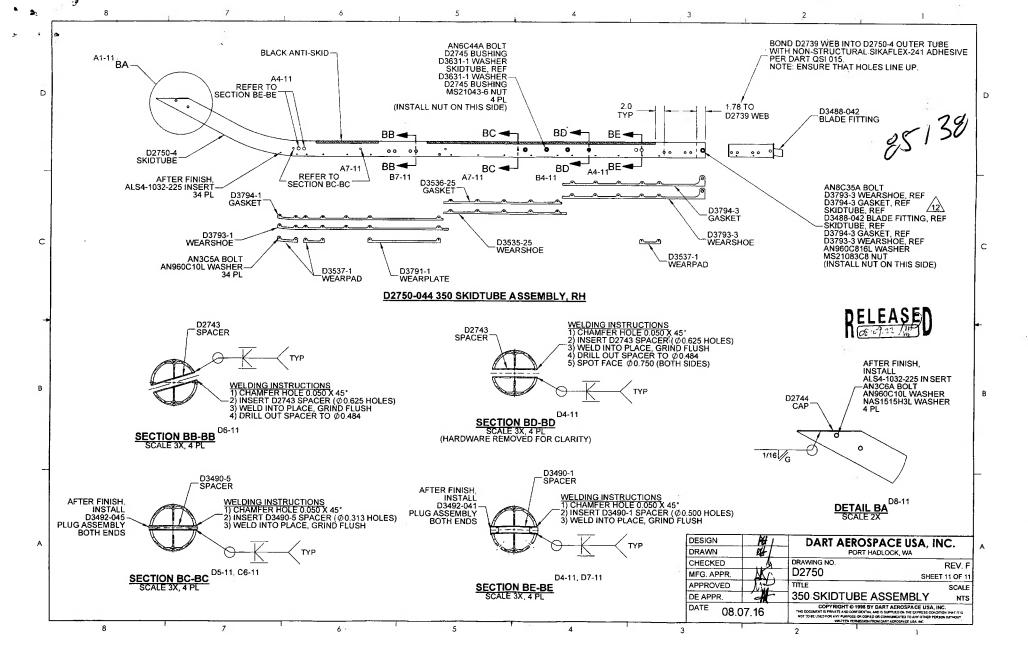
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NO. 294

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Barday Elliott	
Job number: <u>83800</u>	
Part number: 4350-636-012	
Description: Skidtube	
Welding Process: Tig Mig[]	
Base materiel: Allum	
Current: AC[] DC[]	

TEST REQUIREMENTS AND RESULTS

	-	
Visual: Penetration:	pass[] fail[] pass[] fail[]	
UNACCEPTABLE		
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]	
Qualifier Band Aural	Date of Test Coupon 2.05.09	
Welder Boolay Elliott	Date of Test Coupon 12-05-09	
		.1
The above named individual is qualif	ied in accordance with AWS D17.1.2001 to we	;L